Work Orde <i>July-18-12 1:09.</i>	er ID 87366			*	8736	36*							Page 1
Item ID: Revision ID:	D350-567-031			Accept	-	*N900	040	100)*	Setup	Start	*N:	S1*
	Interior Floor Window (Sl	iding Door C	compatible)								Stop	*N	S2*
Start Date: Required Date: Reference:	7/10/12 Start Qt 8/03/12 Reg'd Q	-	*1* *1*			Cust Item I Customer:	D:		·				
Approvals:	Process Plan:M QC:	5	Date: 12/07/19 Date:	Tooling:			ite:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	Operatio Descripti			Set U Run l	p/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									,			
N/A	Rev D										,		
100 *100* DC Document Control	DOCUME	NT CONTROL Memo Photocopy bl	ue file and create labels per	0.00 0.00 PPP D350-5		7/10/03			H	40	√ MC	J)2	-9-14
*110 *110*	Packaging			0.00								12/9	125 P
Packaging Packaging		Memo Pick Packing	Kit	0.00								,	
		***ENSURE	DT 8439 TEMPLATE IS	INCLUDED [®]	**								
*120	QC4-100%	6 Inspect kits f	or completeness	0.00	DA AN	r i			•				
QC Quality Control		Memo		0.00	15 T	166							

NCR:	Yes	/	No

												DQA:	Date	14
NCR:	Yes	/ No					WORK ORDER NON-	·co	NFOR	MANCE / UP	DATE			
												QA Closed:	Date	: `````````````````````````````````````
Work Ord	er.						DISPOSITION		•		AGAINST [EPARTMENT	/PROCESS	
							Rework	٦	ŀ	Skid-tube	Crosstube	1	Water Jet	Engineering
Part l	No.						Scrap	┨ .		Machining	Small Fab	Pro	od. Eng. Coor.	Quality
							Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR	۷o.						Work Order Update			Large Fab	Composite	7	Supplier	
														
Root					Des	-	otion of work order update		Initial		ction	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	C	hief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data			[
quip/Tooling														
perator														
1aterial														
etup														
ther														
rocess	_		[
upplier]	ļ										
raining	-							1						
napproved			<u> </u>		l			ΕΔΙΙ	LT CATE	GORY		<u> </u>	<u> </u>	
Landi	ng (Gear					General	170	LI CAIL	<u> </u>				
		Bending					Bend	Г	Grain		Γ	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	are	ļ l	Over/Unde	r tolerance	Temperature/Cure
		Cracks			ŕ		Broken/Damaged		Inspect	ion Incomplete		Part Incorre	<u> </u>	Weld
	Г	Crushed/	Crimped.				Burrs			tions Incomplete	/Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
		Cuffs	,				Contamination		Mainte	•	ļ	Part Moved		
	Г	Heat Trea	it				Countersink		Mislabe	eled	ļ	Positioned		
		Inspection	n Strip in	Tube			Cut Too Short		Misread		Ī	Power Loss	_	Other
		Ripples in	Bend		:		Drill Holes		Offset		_			
		Torque W	/aves in E	xtrusio	n		Drawing		Out of	Calibration				
		Turning S	equence				Finish		Out of :	Sequence				
		Wave/Tw	ist in Tub	oe .	1		Folio		Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord <i>Jนโ</i> ่y-18-12 1:0		366		*87:	366*						Page 2
Item ID: Revision ID:	D350-567-03	1		Accept	*N900	<u>040</u>	100	* Se	etup Sta	art *N	S1*
Item Name:	Interior Floor	Window (Sliding Door	Compatible)	·					Ste	^{op} *N	S2*
Start Date:	7/10/12	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date	: 8/03/12	Req'd Qty: 1.00	*1*		Customer:						
Reference:								ъ	C/A.		
Approvals:	Process Pla	n:	Date: 1	Tooling:	Da	ate:		R		art *N	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:			St	^{op} *N	IR2*
Sequence ID/ Work Center 1	T D	Operation Description		Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		Destaraine		0.00	20				•		
130 Packaging		Packaging Memo		0.00	AA) 8370	7	-		/4	12/1/2	3
Packaging			1 pack for shipping as per F	PPP D350-567-031	(,	/	//	
140 *4 4 O *		QC21- Final Inspection	- Work Order Release	0.00				1	21	in lid	
140 QC Quality Control		Мето		0.00	•		_	\	2/1	<u> </u>	
Quality Condo											ıi

Linpoy

NCR:	Yes	1	No

DQA: _____ Date: ____

NCR: Y	es/	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	, Date	∦ 4 g _ 3	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROGESS		
Part N	•					Rework Scrap		יו	Skid-tube // Machining	Crosstube Small Fab		Water Jet d. Engligoor.	Engineering Quality	
NCR N	١٥٠ ِ			_		Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other	
Root					Descr	iption of work order update	П	nitial	Ac	tion	Sign &	Verification	1 V	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data												1		
quip/Tooling												and the second s	-	
perator														
1aterial													4.	
etup														
ther														
rocess														
upplier					•							e		
raining														
napproved]		<u> </u>							in the second		
						· · · · · · · · · · · · · · · · · · · 	AUL	T CATE	GORY					
Landi	ng G	1			_	General		1			7			
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
1		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
		Crushed/0	Crimped.		L	Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs Contamination					Contamination	L	Mainte	nance		Part Moved	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	ent.	
:	Heat Treat Countersink] Mislabe	led		Positioned V			
Inspection Strip in Tube Cut Too Short						Cut Too Short		Misread	I		Power Loss/Surge Other			
Ripples in Bend Drill Holes					Offset									
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration			(14) (13) (14) (13) (14) (15) (15)		
·		Turning Se	equence			Finish		Out of S	equence			The Late of		
į		Mayo/Tw	ict in Tub			Tralia		Outsida	Dimonsions			10. 14. 15.		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

87366

Parent Item:

D350-567-031

Parent Item Name:

Interior Floor Window (Sliding Door Compatible)

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

	omponent Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	•	Qty per Kit	Total Qty		ite Stat sued
A_ S(N526G632R12		Purchased	No			120	Each	140.0000	OB S	8	- J	>
					Location		Loc Qty		Loc Code			O	,
					ST344		100			6			
					1223	378	100			X			
					ST346		39						
					121:	556	39						
					ST347		1						
		۱ کود۱			1193	225	1						
, D S	22463 Lead of Scale o	2	Manufactured	No			120	f	479.3174	3.75	3.75		<i>y</i> .
	- Siziliolo) (Location		Loc Oty		Loc Code				
	-/				ST404		479.31737						
					722		15.38						
					794		0.43737				***		
	3210-1		Manufactured	No	835	4 2 —,	463.5 120	Each	6.0000		1	Cont.	,
D	oubler				<u>Location</u>		Loc Oty		Loc Code				ī į
					ST210		6						
′ _					814	97	6)			
_	321141		Manufactured	No	٠	_	120	Each	9.0000		9/13 1	1 58)
В	Bracket				•		T O		I C . 1 .		1 / 1	90	
					Location		Loc Qty		Loc Code				
					ST211		9						
					793	10	1						

81495

NCR:	Yes	1	Nο

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ____ Date: ____

NCR:	es.	/ No				WORK OR	DEK NON-C	.Oiv	IFURN	MAINCE / UPL	DAIE	QA Closed:	Date:	· 16
Nork Orde	or.					DISPO	OSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	•						Rework Scrap		N	Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.	Engineering Quality
NCR f	10.		10.00			Work Ord	Use-as-is ler Update			oforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Desci	ription of work o	rder update	I	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conform	ance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data					-									
quip/Tooling										•				
perator														
1aterial														
etup														
ther														
rocess														
upplier														·
raining														
napproved			<u> </u>								· · · · · · · · · · · · · · · · · · ·			
							F/	AUL	T CATE	GORY				
Landi		1			_	Gene	ral		ı		_	7		٦ .
		Bending			<u> </u> _	Bend		Ш	Grain		_	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route			Hardwa	re		Over/Under	 	Temperature/Cure
		Cracks			L	Broken/Dama	ged	Ш		on Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped.		L	Burrs		$ldsymbol{ld}}}}}}$		ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			Ĺ	Contamination			Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Ш	Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube	L	Cut Too Short		Ш	Misread			Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes			Offset					
		Torque W	aves in E	xtrusio	ո [Drawing			Out of C	Calibration				
		Turning Se	equence			Finish			Out of S	equence				
		Wave/Tw	ist in Tub	oe .	Γ	Folio			Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-18-12 1:09:29 PM

Work Order ID:	87366										
Parent Item:	D350-567-031							Start Date: 7/1	0/12	Required Date	e: 8/03/12
Parent Item Name:	Interior Floor Window (Sli	iding Door Co	mpatit	ole)	* :			Start Qty: 1.0	0	Required Qty	y: 1.00
D3212-f	Man	nufactured	No		120	Eac	h 13.	0000	$\begin{pmatrix} 1 \\ 2 \end{pmatrix}$		EN
Floor Window									2 1		- 187
				Location	Loc	<u>Qty</u>	Loc Co	<u>de</u>			
				ST210		13					
4				79307		6			4		
				81496		7					
D3213-041	Man	nufactured	No	•	120	Eac	h 5.0	000	د () 1		SH :
Door Assembly									-70		~~~
				Location	<u>Loc</u>	<u>Oty</u>	Loc Co	<u>de</u>			
				ST211		5					
				81494	120	5				1	١
DT8439	Man	nufactured	No		120	Eac	n 0.0	000 1	1	\mathcal{Z}	<i>\</i>
template	_		No		120	Eac	.h 11	36.0000	40		
MS20470AD4-5 Rivet, Universal Head	Purc	chased	NO		120	Lac	A1 1,1	30.0000		SP	<u> </u>
				Location	Loc	<u>Oty</u>	Loc Co	<u>de</u>	•		A
				ST319		1136					
λ				118405		389					
				120142		747			40	/ /	
MS20470AD4-6	Purc	chased	No		120	Eac	ch 2,1	29.0000	(3/09)	25/	Ø 3
Rivet, Universal Head									<u> </u>		***
				Location		<u>Oty</u>	Loc Co	<u>de</u>			
				ST319		2129		_			
				117395		16		_			
				118927 119109	•	279 12		_			
				120142		81		_			
				121524		1741			90	•	

												DQA:	Date:	<u> </u>
NCR:	'es	/ No				W	ORK ORDER NON-C	ON	NFORM	//ANCE / UPDA	ATE	QA Closed:	Date:	>
Nork Orde	ır.						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	lo.						Rework Scrap Use-as-is Work Order Update		f Therm	Machining noforming	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descr	•	n of work order update	Initial Action Chief Eng Description				Sign &		
Cause		Date	Step	Qty		or N	on-conformance	Ch	ief Eng	Descript	tion .	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining										·				
. <u></u>							F.A.	UL	T CATE	GORY				
Landi	Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Bom/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish						M/Route bken/Damaged rs ntamination untersink Too Short II Holes awing		Instruct Mainte Mislabe Misread Offset Out of (on Incomplete ions Incomplete/Unc nance led	clear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw			-	Fol	io	Г	1	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-18-12 1:09:29 PM

Work Order ID:	87366									a ^r		
Parent Item:	D350-567-031	• .			٠			Start	Date: 7/10/12	R	equired Date	e: 8/03/12
Parent Item Name:	Interior Floor Window	(Sliding Door Co	mpatibl	e)				Start	Qty: 1:00	I	Required Qty	y: 1.00
MS20470AD4-7		Purchased	No			120	Each	1,336.0000	T ² 0	20	•	=0
Rivet, Universal Head												
				Location		Loc Oty		Loc Code				OV.
				ST139		1019						
				1214	115_	1019			20			
				ST319		52						
				1207	769	52						
				ST320		265						
*				1160		117						
				1186	514	148				— ∧		•
MS210421:06		Purchased	No			120	Each	330.0000	(38)	r#/		
> Nut					-					υ φ		─∀ ,
				Location		Loc Qty		Loc Code				
				ST300		130						
				1183		2						
				1191		1						
				1197		1						
				1214 _1215		26 100			- \Q			
1				ST317	330	200						
				1221	151	200						
NAS1149DN632J		D 1	No	122	131	120	Each	141.0000	-187 I	— _• /)	
Washer		Purchased	140				Euch	111.0000	W LARI	13 ,21	/	RD3
77 431101				Location	•	Loc Oty		Loc Code				
				ST298		141		<u> Loc Couc</u>				
				1184	128	141			8			
				110		171			U			

												DQA:	Date:	2 .	
NCR:	/es	/ No					WORK ORDER NON-C	10	VFOR	MANCE / UPI	DATE	0.4.61	.	· · •	
						-		_				QA Closed:	Date:	,	
Work Order:							DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.							Rework Scrap		Skid-tube Crosstube Machining Small Fab		Water Jet Prod. Eng. Coor.		Engineering Quality		
NCR I	No.						Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Other Supplier		Other	
Root					Desc	rip	tion of work order update	1	nitial	Act	ion	Sign &	·		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	f Eng Description		Date	Verification	QC Inspector	
oc/Data quip/Tooling															
perator															
1aterial															
etup															
ther															
rocess															
upplier								ļ							
raining															
napproved															
							F/	\UL	T CATE	GORY					
Landi	ng (ear					General								
	Bending				Bend		Grain		Γ	Ovalized		Pressure/Forced			
		Centre Not Concentric to O/S			BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
	Cracks			Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld					
	Crushed/Crimped.			Burrs		Instructions Incomplete/Unclear		Part Lost/Missing Wro		Wrong Stock Pulled					
Cuffs				Contamination		Maintenance			Part Moved						
	Heat Treat				Countersink		Mislabeled			Positioned Wrong					
	Inspection Strip in Tube				Cut Too Short		Misread			Power Loss/Surge Other					
	Ripples in Bend				Drill Holes		Offset			I		•			
		Torque W	aves in E	xtrusio	, [\neg	Drawing		Out of Calibration			·			
		Turning Se	equence			┪	Finish		Out of Sequence			 			
	Wave/Twist in Tube					Folio		Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD.

REFERENCE ONLY

Page 28 of 28

PARTS LIST 5.0

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X	017	<u> </u>	<u> </u>			D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
							
1	1	1				D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	 '	1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		 	- `-	1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
 	 1 	 	1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1	 	1	 		1	D350-567-031	INTERIOR FLOOR WINDOW KIT
l '	1	•					(SLIDING DOOR COMPATABLE)

- <u></u>	O4 I	04.	Oty	Oby		
Qty	Qty	Qty	Qty -115	Qty -031	Part Number	Description
-013	-023	-113	-115	-0.51	D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
<u> </u>					D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
	Х				D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
		Х	- V		D350-567-115	INTERIOR FLOOR WINDOW KIT
			Х	X	D350-567-031	INTERIOR FLOOR WINDOW KIT
					ו כט-/ספ-טפנע	(SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
					D2126-0600	SEAL
11					D2463-0750	NEOPRENE SEAL
	1	1		 	D2463-0860	NEOPRENE SEAL
		12			2600-6	1/4 TURN FASTENER
	9	12			2600-U	WASHER
	9	12			212-12	RECEPTACLE
	9	21			AN526C832R9	SCREW (OR AN526C832-9,OR MS51957-126)
	22 44	42			AN960JD8	WASHER
	22	21		 	MS21042L08	NUT (OR MS21042-08)
	18	24	··	 	MS20426AD3-5	RIVET
0.00	2 SQ.	2 SQ.			N/A	9 70z 7781 'S' GLASS UNIVERSAL WEAVE
2 SQ. YD	YD YD	YD YD			''''	
	 	- 10				
				1	D2463-0450 \$	NEOPRENE SEAL
				(1	-D3210-1	DOUBLER
				71	TD3211-1 /	BRACKET
				21-	D3212-1-	FLOOR WINDOW
				/ 1	D3213-041 /	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
	1		1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	/ 8	AN526C632R12	~SGREW (OR AN526C632-12, OR MS51957-32)
			9	/-8-	~AN960JD6~	WASHER
······································	1		9	8	MS21042L06 /	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90~	MS20470AD4-6	-RIVET
t			15	20	MS20470AD4-7	RIVET

• COPYRIGHT © 2000 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D

Date: 08.07.08